


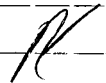




# Work Order ID 62776

Friday, October 08, 2010 8:02:36 AM


Page 1

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	10/8/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	1.00	Customer:		
Reference:						


Approvals:	Process Plan:		Date:	10-10-08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab									
Large Fab	Memo	0.00							
	1- assemble all ribs in DT9446 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9446 jig								
	3- to locate hinges and shims use D2989-041, weld as per dwg D2989								
	A/R ER316 S.S. Rod Batch: 111585								

Cpl 10.12.13

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC									
Quality Control	Memo	0.00							

10.12.13

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




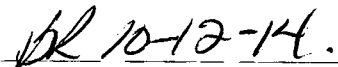
**Work Order ID 62776**

Friday, October 08, 2010 8:02:36 AM

Page 2

Item ID: D2989-043 Accept  Setup Start   
Revision ID:  
Item Name: Basket Lid Assembly Stop   
Start Date: 10/8/2010 Start Qty: 1.00  Cust Item ID:  
Required Date: 10/15/2010 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00		8 10/12/13					
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00 0.00							1  10-12-14.

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 62776**

Friday, October 08, 2010 8:02:36 AM



Page 4

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	10/8/2010	Start Qty:	1.00			
Required Date:	10/15/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> <i>W/O 62774</i> Memo	0.00 0.00							<i>ES 10/12/15 @</i>
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/12/16 J</i> <i>ME</i> <i>10-12-15</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, October 08, 2010 8:02:40 AM

Page 1

Work Order ID: 62776

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	14.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14					
				61091				2					
				61424				12					
D2989-3 		Manufactured	No			100	Each	5.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
				59006				1					
				59034				1					
				61393				3					
D2989-4 		Manufactured	No			100	Each	3.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				3					
				61394				3					

1  
 10.12.08  
 B63628 → ①  
 1  
 10.12.08  
 B63198 → ①  
 1  
 10.12.08  
 B63199 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Friday, October 08, 2010 8:02:40 AM

Page 2

Work Order ID: 62776

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-5

Manufactured No

100 Each

8.0000

2<sup>2</sup>



Rib



*Cpl 10.12.08*

Location

Loc Qty

Loc Code

WA

8

61396

4

62367

4

*B63200 → ②*

D3182-1

Manufactured No

100 Each

12.0000

2<sup>2</sup>



Hinge



*Cpl 10.12.08*

Location

Loc Qty

Loc Code

WA

12

61395

2

62358

6

62365

4

*B63197 → ②*

D3442-3

Manufactured No

100 Each

6.0000

2<sup>2</sup>



Shim



*Cpl 10.12.08*

Location

Loc Qty

Loc Code

WA

6

61176

4

61756

2

*B63054 → ②*

D3827-041

Manufactured No

100 Each

9.0000

1<sup>1</sup>



Rib Assembly (Inboard)



*Cpl 10.12.08*

Location

Loc Qty

Loc Code

WA

9

61177

3

61758

6

*B63959 → ①*

Friday, October 08, 2010 8:02:40 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 08, 2010 8:02:40 AM

Page 3

Work Order ID: 62776

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-5

Manufactured No

100

Each

4.0000

1



Mesh (Lid)

Location

Loc Qty

Loc Code

WA

4

60671

1

61759

3

B63004 → ①

D3833-5

Manufactured No

100

Each

7.0000

2



Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

7

53722

1

60673

2

61317

4

B63055 → ②

D3838-041

Manufactured No

100

Each

3.0000

1



Rib Assembly (Basket Lid, LH)

Location

Loc Qty

Loc Code

WA

3

61397

3

B63195 → ①

D3838-042

Manufactured No

100

Each

1.0000

1



Rib Assembly (Basket Lid, RH)

Location

Loc Qty

Loc Code

WA

1

61398

1

B63196 → ①

Friday, October 08, 2010 8:02:40 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
  - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

**RELEASED**  
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-17; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-11/-12 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	RAS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



8

7

6

5

4

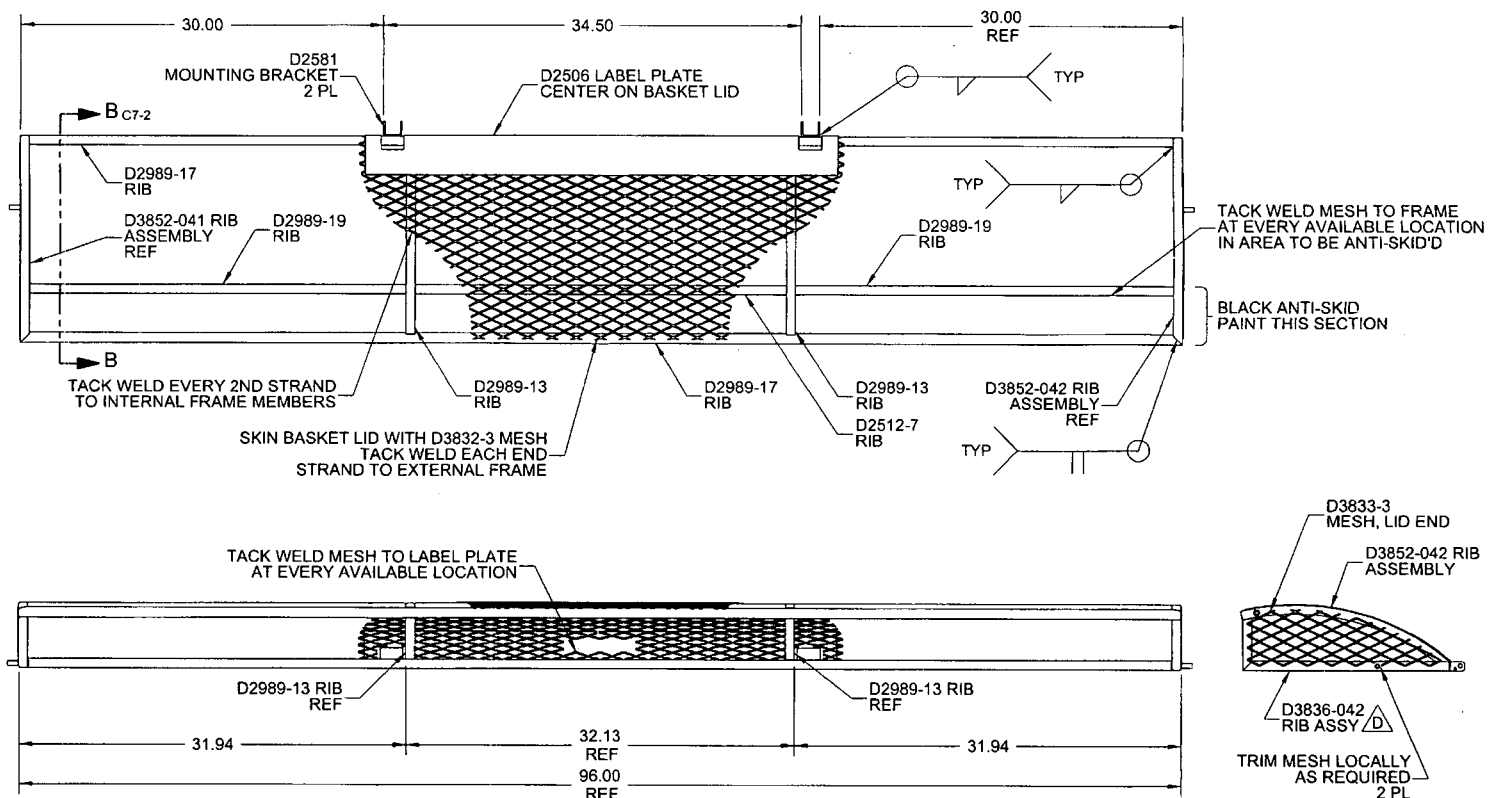
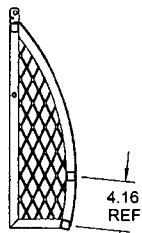
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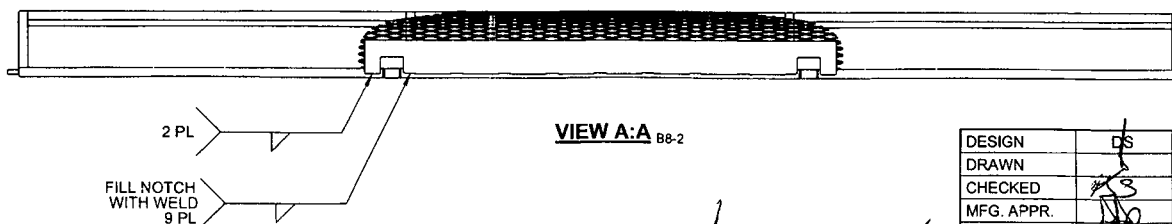
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**SECTION B-B**

D7-2






**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



**VIEW A-A** B8-2

**RELEASED**  
08/11/18/19

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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*also 62774*

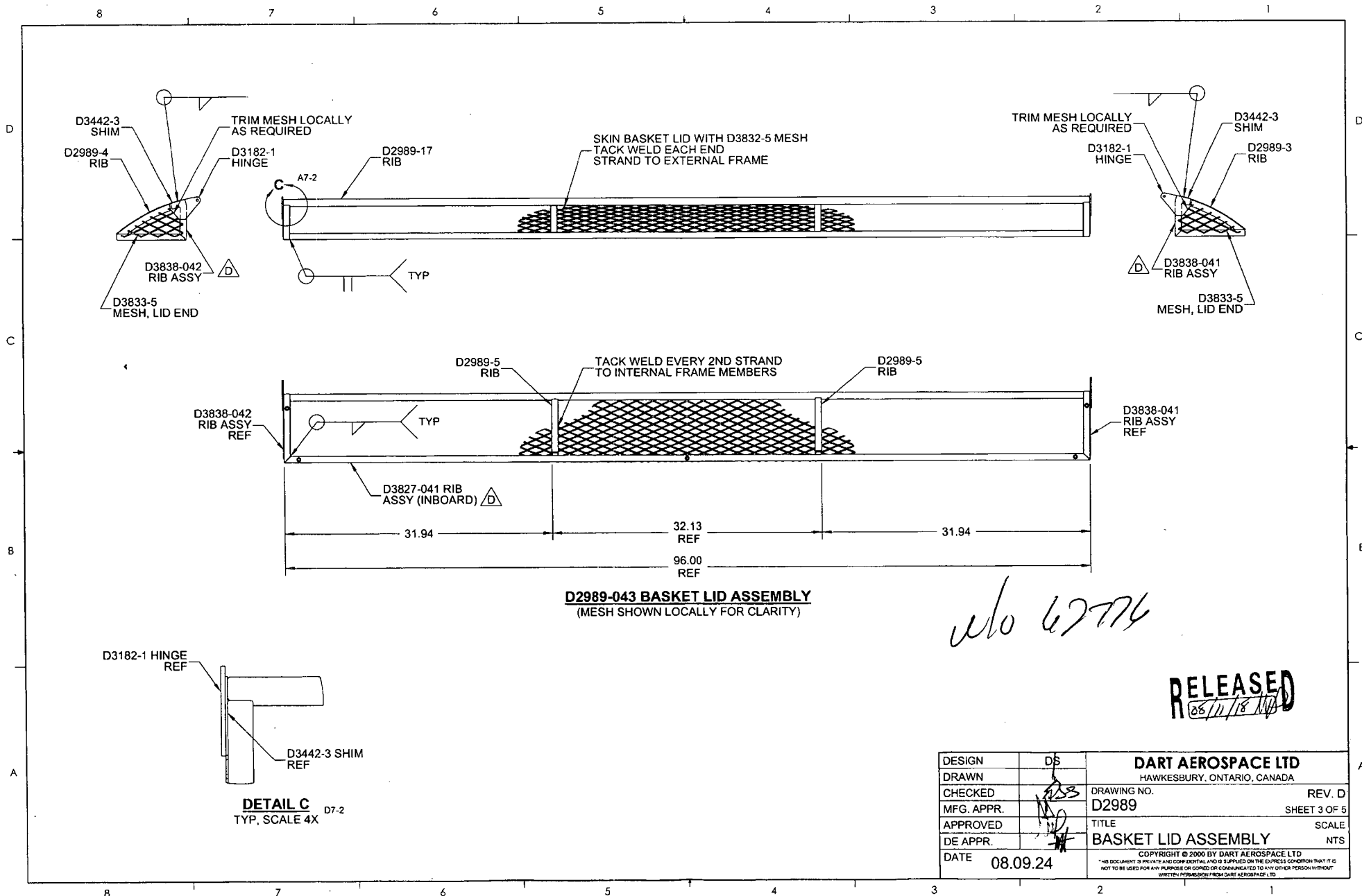
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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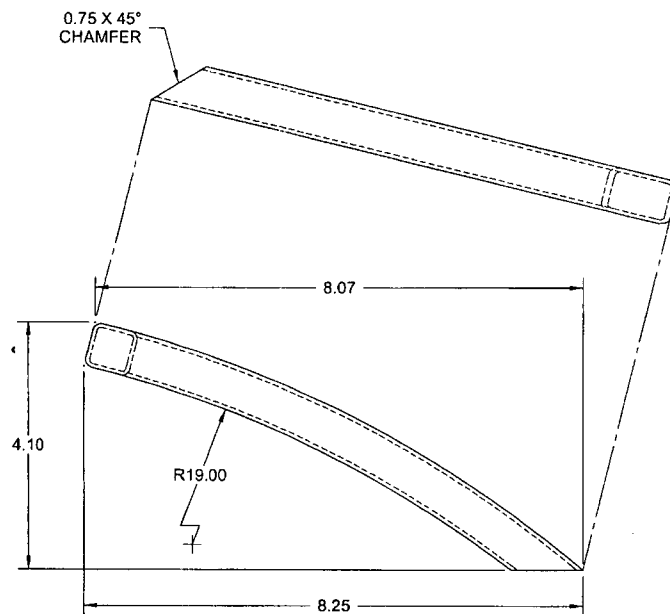
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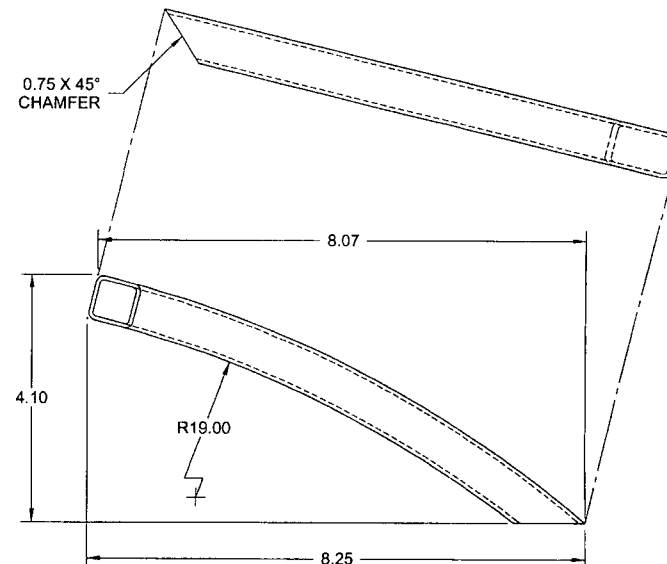
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**D2989-3 RIB**

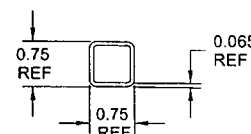


**D2989-4 RIB**

*u/o a2776*

**RELEASED**  
08/10/18 AM

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION  
VIEW**

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

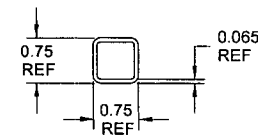
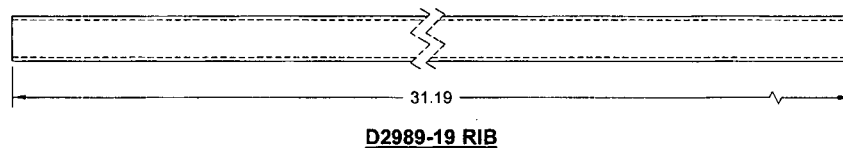
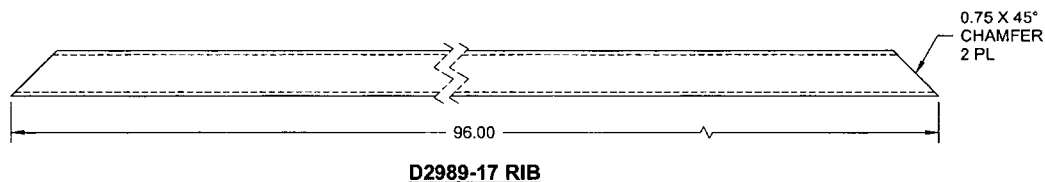
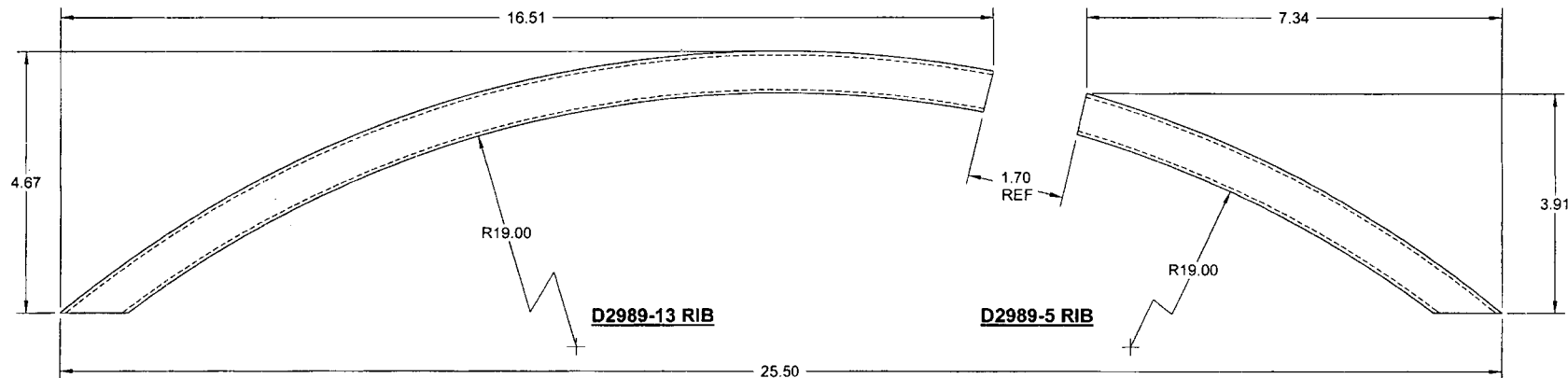
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries